

June-16-14 1:16:10 PM

Page 1

Quality Control

DAS
38
9-89

DEC 01 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Re/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Re/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 121015

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121015

Page 2

Item ID: D4880-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206A/B FWD Leg Assembly, LH
 Start Date: 6/16/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/16/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						2	FF		DEC 02 2014
Small Fab	Memo	0.00							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9971 A/R HYSOL BATCH: <u>H130458</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							DAS
140						(2)			38
QC	Memo	0.00							9-89
Quality Control									DEC 01 2014
150	Identify as per dwg & Stock Location: <u>St135</u>	0.00							DAS
150						(2)			46
Packaging	Memo	0.00							9-89
Packaging									DEC 02 2014

cutsource
rev.

P10: 26707 P&L

C 214/12/103 2

2x SP15-01-7.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Work Order ID 121015

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121015

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Item ID: D4880-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: 206A/B FWD Leg Assembly, LH

Start Date: 6/16/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/16/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MJ 1501-09

ST 135 CH 15-01-08

14-12-02

15-1-8

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Picklist Print

June-16-14 1:16:09 PM

Page 1

Work Order ID: 121015

121015

Parent Item: D4880-041

D4880-041

Parent Item Name: 206A/B FWD Leg Assembly, LH

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4880-1		Manufactured	No		121611		Each	0.0000		1			
D4880-1									**	2	FF	DEC 01 2014	
Strut													
D4883-7		Manufactured	No		113536		Each	0.0000		1			
D4883-7									**	2	FF	DEC 01 2014	
End Fitting													
D4884-1		Manufactured	No		117346		Each	0.0000		1			
D4884-1									**	2	FF	DEC 01 2014	
End Fitting, Eye													
HL20PB5-12		Purchased	No				Each	236.0000		4			
HL20PB5-12									**		FF	DEC 01 2014	
Rivet													
HL32PB5-12													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST281	129912		236			8			
				M128110			38						
				M128973			198						
HL86-5		Purchased	No				Each	297.0000		4			
HL86-5									**		FF	DEC 01 2014	
Collar													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST280	129864		12			8			
				M128110			12						
				ST284			285						
				M128228			85						
				M129022			200						

DQA: _____ Date: _____



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26707**

Purchase Order Date 12/3/2014

PO Print Date 12/3/2014

Page Number 4 of 6

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$4.

10	123523	D4867-041 LEG ASSEMBLY	12/5/2014	2.00	\$4.00	\$8.
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Yes
12/5/2014

Line Total: \$8.

11	121459	D4878-041 LEG ASSEMBLY	12/5/2014	2.00	\$4.00	\$8.
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Yes
12/5/2014

LASER MARKED

Line Total: \$8.

12	121015	D4880-041 LEG ASSEMBLY	12/5/2014	2.00	\$4.00	\$8.
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Yes
12/5/2014

LASER MARKED

SP15-01-7

Note:

12/3/2014

